

**TABLE 1**  
**FLAW ACCEPTANCE CRITERIA FOR  $\frac{1}{2}$  in. (13 mm) TO**  
**LESS THAN 1 in. (25 mm) THICK WELD**

	$a/t$	$t$
Surface flaw	$\leq 0.087$	$\leq 0.25$ in. (6.4 mm)
Subsurface flaw	$\leq 0.143$	$\leq 0.25$ in. (6.4 mm)

**GENERAL NOTES:**

- (a)  $t$  = the thickness of the weld excluding any allowable reinforcement. For a butt weld joining two members having different thicknesses at the weld,  $t$  is the thinner of these two thicknesses. If a full penetration weld includes a fillet weld, the thickness of the throat of the fillet weld shall be included in  $t$ .
- (b) A subsurface indication shall be considered as a surface flaw if the separation ( $S$  in Fig. 1) of the indication from the nearest surface of the component is equal to or less than half the through thickness dimension ( $2a$  in Fig. 1, sketch (b)) of the subsurface indication.

imaged flaws with recorded lengths, including the maximum allowable flaws, have an indicated length equal to or greater than the actual length of the flaws in the qualification block.

(d) The ultrasonic examination shall be performed using a device employing automatic computer based data

acquisition. The initial straight beam material examination (T-472 of Section V, Article 4) for reflectors that could interfere with the angle beam examination shall be performed (1) manually, (2) as part of a previous manufacturing process, or (3) during the automatic UT examination provided detection of these reflectors is demonstrated [subpara. (c)].

(e) Data is recorded in unprocessed form. A complete data set with no gating, filtering, or thresholding for response from examination volume in para. (a) above shall be included in the data record.

(f) Personnel performing and evaluating UT examinations shall be qualified and certified in accordance with their employer's written practice. ASNT SNT-TC-1A or CP-189 shall be used as a guideline. Only Level II or III personnel shall analyze the data or interpret the results.

(g) Contractor qualification records of certified personnel shall be approved by the Certificate Holder and maintained by their employer.

(h) In addition, personnel who acquire and analyze UT data shall be trained using the equipment in (d) above, and participate in the demonstration of (c) above.

**TABLE 2**  
**FLAW ACCEPTANCE CRITERIA FOR 1 in. (25 mm) TO 12 in. (300 mm) THICK WELD**

Aspect Ratio, $a/t$	1 in. (25 mm) $\leq t \leq 2\frac{1}{2}$ in. (64 mm) [Note (1)]		4 in. (100 mm) $\leq t \leq 12$ in. (300 mm) [Note (1)]	
	Surface Flaw, $a/t$	Subsurface Flaw, $a/t$	Surface Flaw, $a/t$	Subsurface Flaw, $a/t$
0.05	0.031	0.034	0.019	0.020
0.05	0.033	0.036	0.020	0.022
0.10	0.036	0.043	0.022	0.025
0.15	0.041	0.049	0.025	0.029
0.20	0.047	0.057	0.028	0.033
0.25	0.055	0.066	0.033	0.036
0.30	0.064	0.076	0.038	0.044
0.35	0.074	0.090	0.044	0.051
0.40	0.083	0.105	0.050	0.058
0.45	0.085	0.123	0.051	0.067
0.50	0.087	0.143	0.052	0.076

**GENERAL NOTES:**

- (a)  $t$  = thickness of the weld excluding any allowable reinforcement. For a butt weld joining two members having different thicknesses at the weld,  $t$  is the thinner of these two thicknesses. If a full penetration weld includes a fillet weld, the thickness of the throat of the fillet weld shall be included in  $t$ .
- (b) A subsurface indication shall be considered as a surface flaw if separation ( $S$  in Fig. 1) of the indication from the nearest surface of the component is equal to or less than half the through thickness dimension ( $2a$  in Fig. 1, sketch (b)) of the subsurface indication.
- (c) If the acceptance criteria in this Table results in a flaw length,  $l$ , less than 0.25 in. (6.4 mm), a value of 0.25 in. (6.4 mm) may be used.

**NOTE:**

- (1) For intermediate flaw aspect ratio  $a/t$  and thickness  $t$  ( $2\frac{1}{2}$  in. (64 mm)  $< t < 4$  in. (100 mm)) linear interpolation is permissible.



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